

backing-up screw *W* and the facing of the blank was accomplished by the same tool. This fixture took care of seven gear blanks of various sizes and gave very satisfactory results.

Adjustable Fixture with Means of Maintaining Accuracy. — A fixture which is somewhat out of the ordinary and which may be adjusted to handle several sizes of work *A* is shown in Fig. 3. As absolute concentricity is required in the finished surfaces of the work machined in this fixture, it is essential for the fixture to be arranged in such a way that it can be trued up if it becomes inaccurate through misuse or neglect. The

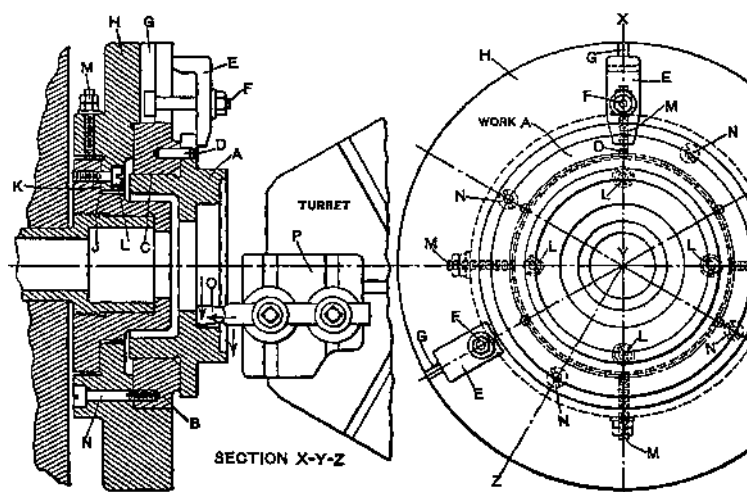


Fig. 3. Fixture in which Provision is made to Compensate for Inaccuracy resulting from Misuse or Neglect

cast-iron nose-piece / is screwed to the spindle in the usual manner and the supplementary casting *H* is bolted to it with the four bolts *L*. The holes in this piece are slightly larger than the bolts so that small adjustments may be made. The flanged portion of the supplementary casting carries four headless set-screws at *M*, by means of which the ring

can be trued up, and check-nuts are provided to secure a permanent setting of the fixture. The locating rings *C* are made in several sizes to take the various pieces that are machined in this fixture, and each of these rings is furnished with a driving pin *D* which enters one of the bolt holes in the work.